

Work Order ID 70863

Thursday, June 16, 2011 11:54:22 AM



Page 1

Item ID: D3512-1

Revision ID:

Item Name: Wearplate

Start Date: 6/16/2011 Start Qty: 8.00

Required Date: 6/23/2011 Req'd Qty: 8.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date: 6/16/11

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept  
Qty Reject  
Qty Reject  
Number Insp.  
Stamp

Draw Nbr

Revision Nbr

D3512

Rev C

100



Waterjet

FLOW WATER JET

0.00

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3512  
Deburr if necessary

Dwg Rev: C

Prog Rev: C 2-

B11-6-20

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B11-6-20

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

Sulox 120

(13)

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Thursday, June 16, 2011 11:54:22 AM

Page 2



Accept



Setup Start



Stop



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Cust Item ID:

Customer:

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QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

130



Brake NC

Brake NC

Operation  
Description

NC BRAKE

Set Up/  
Run Hours

0.00

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Memo

0.00

Deburr if necessary Form as per dwg D3512 using DT8179

28 11/06/20

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 11/06/20

(+13)

150



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

Weld hard surface using DT8874 as per Dwg D3512 & QSI 004 Qty  
Description Batch A/R 2059b Hardecoat Rod M118095

11-6-23

(X7)

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Page 3

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Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

160



QC

Quality Control

Operation  
Description

QC10- Inspect visual per QSI004- ground welds

Set Up/  
Run Hours

0.00

Memo

0.00

8/16/24

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/16/24

(47) ~~Signature~~

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

320°F

8:45

8:15

7x 8m-14/6/24

M115128

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Page 4

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

190



QC

Quality Control

Operation  
Description

QC3- Inspect Part Finish

Memo

Set Up/  
Run Hours

0.00

0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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7 0 11-6-24

200



Packaging

Packaging

Identify as per dwg & Stock Location: stru

Memo

0.00

0.00

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

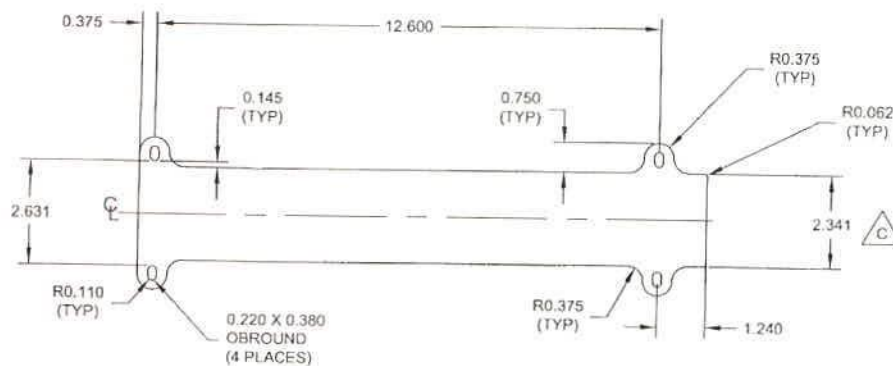
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*[Handwritten signature]*  
11/6/27  
MF  
11-06-24



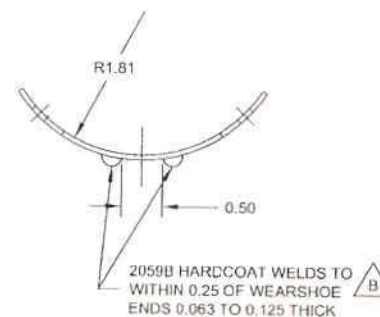




D3512-1F FLAT PATTERN



D3512-1 BENDING DETAIL



SECTION A-A  
SCALE 2:3



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs

REVISIONS  
REVISION 1  
REVISION 2  
REVISION 3  
REVISION 4  
REVISION 5  
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REVISION 100

RELEASED  
07-11-16

C	ENLARGE OBROUND FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.05		

DART AEROSPACE USA, INC  
PORT HADLOCK, WA

DRAWING NO  
D3512  
TITLE  
WEARPLATE  
SCALE  
1:3

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